

Work Order ID 119866

May-28-14 8:47:47 AM

119866

Page 1

Item ID: D4148-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Lug Plate, Fwd

Start Date: 5/28/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/28/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4148

E

0.00

100

100

Waterjet

FLOW CNC Waterjet

Memo

0.00

Cut as per dwg D4148

Prog Rev: E

Dwg Rev: E

Debur as required

Open Holes to size as per dwg

8

⊙

DAS
37
9-89

14-05-28

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

8

⊙

DAS
37
9-89

14-05-28

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May-28-14 8:47:47 AM

Item ID: D4148-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Lug Plate, Fwd

Start Date: 5/28/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/28/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 6-A

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

DAS

27

9-89

14/5/29

8

8x

14/05/29

14/5/30

14/05/29

DAS
36
9-89

Picklist Print

May-28-14 8:47:46 AM

Page 1

Work Order ID: 119866

119866

Parent Item: D4148-1

D4148-1

Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 5/28/14

Required Date: 5/28/14

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.10.29 as per revC DD verf:EC

11.03.02 AS PER DWG REV.D DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

157.0000

0.3607

8

M304S11GA

**

July-05-29

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

157

122521

30

M128254

127

128254

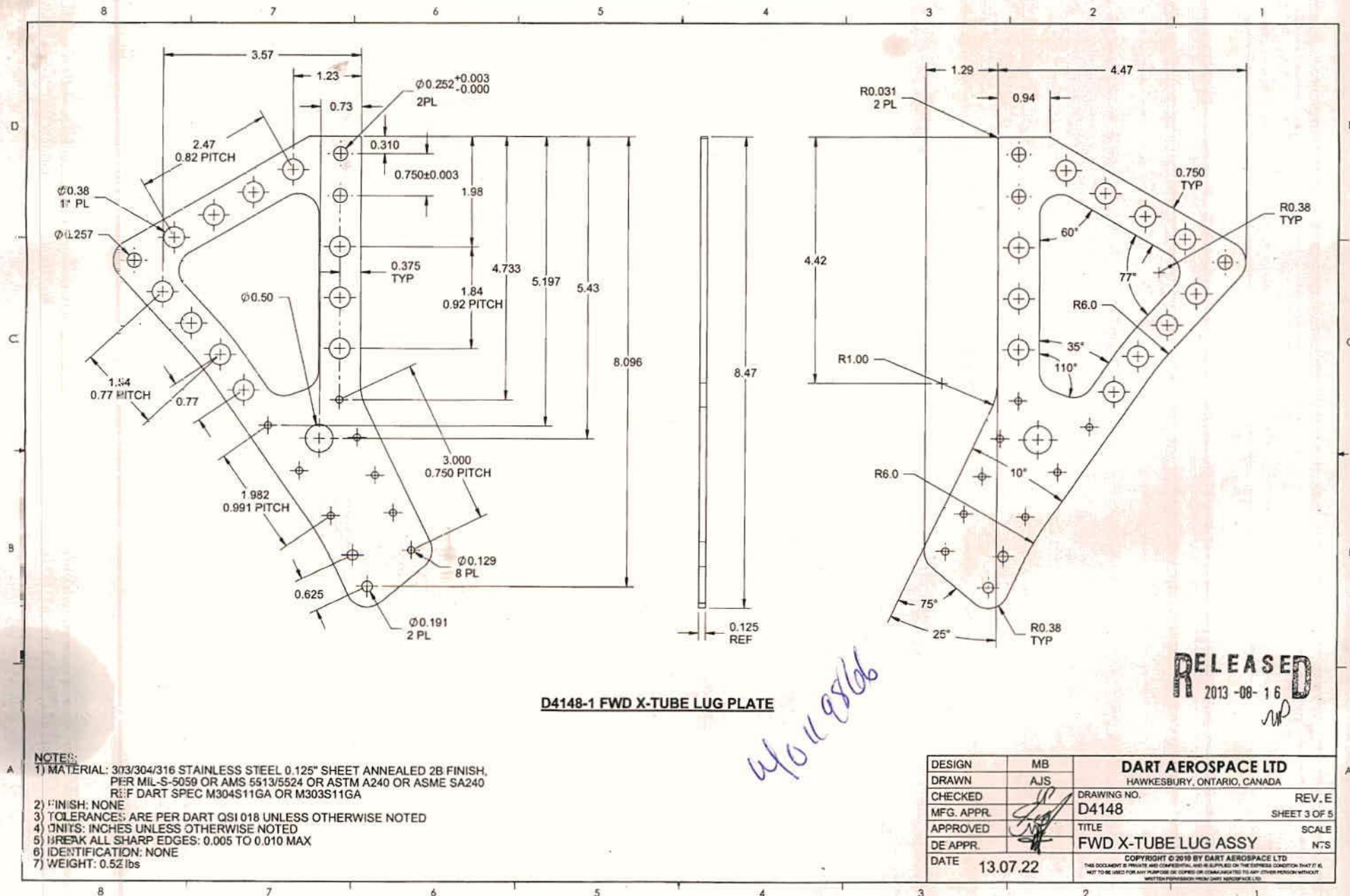
DART AEROSPACE LTD		Work Order:	119806
Description: Fwd Crosstube Lug Plate		Part Number:	D4148-1
Inspection Dwg: D4148 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130"	-		✓	Jkmos
Ø0.191	+0.005/-0.001	0.192"	-		✓	
Ø0.38	+0.006/-0.001	0.38"	-		✓	
Ø0.257	+0.006/-0.001	0.260"	-		✓	
Ø0.50	+0.008/-0.001	0.502"	-		✓	
0.94	+/-0.030	0.94"	-		✓	
4.47	+/-0.030	4.47"	-		✓	
0.750	+/-0.010	0.753"	-		✓	
8.47	+/-0.030	8.47"	-		✓	
8.096	+/-0.010	8.096"	-		✓	Jkmos
5.43	+/-0.030	5.43"	-		✓	
5.197	+/-0.010	5.197"	-		✓	
4.733	+/-0.010	4.733"	-		✓	
0.310	+/-0.010	0.312"	-		✓	
0.750	+/-0.010	0.754"	-		✓	
0.375	+/-0.010	0.377"	-		✓	
1.84	+/-0.030	1.84"	-		✓	
0.92	+/-0.030	0.92"	-		✓	
3.000	+/-0.010	3.004"	-		✓	
0.750	+/-0.010	0.752"	-		✓	
0.625	+/-0.010	0.628"	-		✓	
1.982	+/-0.010	1.984"	-		✓	
0.991	+/-0.010	0.991"	-		✓	
0.77	+/-0.030	0.77"	-		✓	
1.54	+/-0.030	1.54"	-		✓	
2.47	+/-0.030	2.47"	-		✓	
0.82	+/-0.030	0.82"	-		✓	
3.57	+/-0.030	3.57"	-		✓	
1.23	+/-0.030	1.23"	-		✓	
0.73	+/-0.030	0.73"	-		✓	
0.125	+/-0.010	0.116"	-		✓	
Ø0.252	+0.003/-0.000	0.254"	-		✓	

Measured by:	DAS 37 9-89	Audited by:	27 -89	Preliminary Approval:	
Date:	14.05.28	Date:	14/5/29	Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.10.08	Dwg Rev updated	KJ	
C	10.11.05	Dimensions updated per Dwg Rev C	KJ	
D	11.03.08	Dwg Rev updated	KJ	
E	12.02.01	Dimensions updated per Dwg Rev D	KJ	
F	13.11.26	Dwg Rev updated	KJ	



D4148-1 FWD X-TUBE LUG PLATE

4/01/98/66

RELEASED
2013-08-16

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.52 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4148	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	N/S
DATE	13.07.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	